

DART AEROSPACE LTD	Work Order :	22418
K10007 R# 340	Description:	Inspection
	Approval :	
		Page 1 of 1

Step	Location	Procedure	By	Date																																
1	PK	Remove from Stock Yes/No Return# <u>340</u>  <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td><u>1</u></td> <td><u>K10007</u></td> <td><u>Damper kit</u></td> <td><u>B21580</u></td> </tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	<u>1</u>	<u>K10007</u>	<u>Damper kit</u>	<u>B21580</u>																	<u>id</u>	<u>05-02-14</u>								
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<u>1</u>	<u>K10007</u>	<u>Damper kit</u>	<u>B21580</u>																																	
2		Re-work/Inspection: <u>(A) Inspect kit for completeness</u> <u>(B) Report back as per PPP K10007</u> <u>(C) Marketing/shipping to return to inventory</u>	<u>id</u> <u>cd</u>	<u>05-02-14</u> <u>05/02/14</u>																																
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	DC	Close W/O Inspect Level 21	<u>2.51</u> <u>5uc</u> <u>HA</u>	<u>05-02-16</u> <u>05.02.16</u>																																

BB 05-02-16 RR

1-44

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	21580
<b>Description:</b> Bearpaw Kit (19" x 16")		<b>Part Number:</b>	K10007
<b>Dwg:</b> D2435 Rev. E1; DSK086-3 Rev. A		<b>Qty:</b>	20
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Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required</b>	HA	04.09.23	20																																																
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 <b>(Bag Bluefiles separately)</b>	HA 42 HA DH	04.10.06	20																																																
3	GA	<b>Cut 2 blanks per K10007 Kit</b> Cut blank: 16.00" x 19.50" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMWB10) Batch: M15411	gml	04/10/13	20																																																
4	MV	Inspect material for defects or damage prior to machining	gml	04/10/13	20																																																
5	MV	Machine as per Folio D2435 and Dwg D2435 <b>Identify as D2435</b>	gml	04/10/19	20																																																
6	QC2	Inspect parts as they come of the CNC machine	gml	04/10/19	20																																																
7	MV	Deburr	gml	04/10/19	20																																																
8	QC8 & 5	Second inspection	B	04.10.19	20																																																
9	KP	<b>Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3)</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B21185</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block B21185</td><td>B20927</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B21580</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B20963B</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B20388</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt M14544</td><td>M10538-21</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M14311</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M15321</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M14764</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp M14019</td><td>M15364 / M16020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B21185	8	D2274	Radius Block B21185	B20927	2	D2435	Bearpaw	B21580	4	D2438	Clamp	B20963B	8	D2529	Washer	B20388	8	AN4-15A	Bolt M14544	M10538-21	8	AN4-17A	Bolt	M14311	16	AN960JD416	Washer	M15321	8	MS21042L4	Nut (or -4)	M14764	2	QS200M44S	Clamp M14019	M15364 / M16020	1	Paperwork package from Step 2			gml	04-11-02	20
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10	QC4	Inspect Kit for 100% Completeness on the W/O	B	04/11/02	20																																																
11	PK	Identify and pack for shipping as per PPP K10007 <b>Rev: E</b>	B	04/11/02	20																																																
12	AC	Cost / part 156.48	gml	04-11-03	20																																																
13	DC	Close W/O 153.92 Inspect Level 21	HA	04.11.05	20																																																

REFERENCE ONLY

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	
E	04.02.17	Blank size changed, tolerance added to Step 3	KJ/JLM	

RELEASED  
04.02.20